

4172-120

**Section I (Amendments to the Claims)**

Please amend claims 1, 23, 44, 56, 66, 71, 76-78 and 80 and add new claims 81-87 as set out in the following listing of claims 1-87:

1. **(Currently amended)** A method for forming a polymeric hollow fiber, comprising the steps of:
  - (a) providing a string or tow of a solid core fiber;
  - (b) passing the string or tow of the solid core fiber through an extrusion die while concurrently extrusion coating at least one ~~substantially-circumferentially-uniform~~ layer of a removable substrate material over said solid core fiber;
  - (c) extrusion coating at least one ~~substantially-circumferentially-uniform~~ layer of a polymeric membrane-forming material over said removable substrate material layer;
  - (d) treating said polymeric membrane-forming material layer to form a solidified polymeric membrane; and
  - (e) removing the removable substrate material layer and the solid core fiber from the solidified polymeric membrane, to form a polymeric hollow fiber comprising a ~~substantially-circumferentially-uniform~~ tubular membrane wall enclosing an elongated lumen therein.
2. **(Original)** The method of claim 1, wherein said removable substrate material comprises material selected from the group consisting of sublimable materials, meltable materials, and soluble materials.
3. **(Original)** The method of claim 1, wherein said removable substrate material comprises soluble material selected from the group consisting of acid-soluble materials, alkali-soluble materials, organic-solvent-soluble materials, and water-soluble materials.
4. **(Original)** The method of claim 1, wherein said removable substrate material comprises water-soluble polymeric material selected from the group consisting of polyvinyl pyrrolidones (PVP), polyvinyl alcohols (PVA), and polyethylene glycols (PEG).
5. **(Original)** The method of claim 1, wherein said solid core fiber comprises material selected from the group consisting of metals, metal alloys, glass, ceramics, carbons, polymers, and mixtures thereof.
6. **(Previously presented)** The method of claim 1, wherein said solid core fiber has a cross-sectional outer diameter in a range of from about 10 microns to about 10 millimeters.

4172-120

7. **(Original)** The method of claim 1, wherein said polymeric membrane-forming material comprises polymeric material selected from the group consisting of polysulfone, polypropylene, polyacrylonitrile, polytetrafluoroethylene, polyethylene, polyvinylidene fluoride, polyamide, polyethyl methacrylate, regenerated cellulose acetate, cellulose triacetate, and mixtures thereof.
8. **(Original)** The method of claim 1, wherein said polymeric membrane-forming material comprises ion-exchange polymeric material selected from the group consisting of perfluorocarbon-sulfonic-acid-based polymers, polysulfone-based polymers, perfluorocarboxylic-acid-based polymers, styrene-vinyl-benzene-sulfonic-acid-based polymers, styrene-butadiene-based polymers, and mixtures thereof.
9. **(Original)** The method of claim 1, wherein said polymeric membrane-forming material comprises perfluorosulfonate ionomer.
10. **(Original)** The method of claim 9, wherein said perfluorosulfonate ionomer is solution extruded over said removable substrate material layer.
11. **(Original)** The method of claim 10, wherein the treatment of said perfluorosulfonate ionomer comprises the steps of: (i) drying said perfluorosulfonate ionomer at a first elevated temperature; and (ii) curing said perfluorosulfonate ionomer at a second elevated temperature.
12. **(Original)** The method of claim 11, wherein the first elevated temperature is in a range of from about 25°C to about 100°C.
13. **(Original)** The method of claim 11, wherein the second elevated temperature is in a range of from about 110°C to about 250°C.
14. **(Original)** The method of claim 1, wherein one or more reinforcing fibers are incorporated into said at least one polymeric membrane-forming material layer to form a fiber-reinforced polymeric membrane.
15. **(Original)** The method of claim 14 wherein the solid core fiber has a longitudinal axis, and wherein said reinforcing fibers extend continuously along the longitudinal axis of said solid core fiber.

4172-120

16. **(Original)** The method of claim 14 wherein said reinforcing fibers comprises fibers selected from the group consisting of fiberglass, carbon fibers, metal fibers, resin fibers, and composite fibers.
17. **(Original)** The method of claim 14, wherein said reinforcing fibers comprises fiberglass yarns.
18. **(Original)** The method of claim 17, wherein said fiber glass yarns are characterized by an average outer diameter in a range of from about 0.1 $\mu$ m to about 500 $\mu$ m.
19. **(Original)** The method of claim 14, wherein said reinforcing fibers are co-extruded with said polymeric membrane-forming material layer.
20. **(Original)** The method of claim 14, wherein two layers of polymeric membrane-forming material are coated over said removable substrate material layer, and wherein said reinforcing fibers are encapsulated between said two polymeric membrane-forming material layers.
21. **(Original)** The method of claim 1, further comprising the step of providing a removal interface in contact with at least a portion of the removable substrate material layer, to facilitate removal of said removable substrate material.
22. **(Original)** The method of claim 21, wherein said removal interface comprises an open cavity, through which a removing fluid can be passed through to remove said removable substrate material.
23. **(Currently amended)** A method for forming a polymeric hollow fiber, comprising the steps of:
- (a) providing a string or tow of a solid core fiber comprising removable substrate material;
  - (b) passing the string or tow of the solid core fiber through an extrusion die while concurrently extrusion coating at least one ~~substantially-circumferentially-uniform~~ layer of polymeric membrane-forming material over said solid core fiber;
  - (c) treating said polymeric membrane-forming material layer to form a solidified polymeric membrane; and
  - (d) removing the solid core fiber from the solidified polymeric membrane, to form a polymeric hollow fiber comprising a ~~substantially-circumferentially-uniform~~ tubular membrane wall enclosing an elongated lumen therein.

4172-120

24. **(Original)** The method of claim 23, wherein said removable substrate material comprises material selected from the group consisting of sublimable materials, meltable materials, and soluble materials.
25. **(Original)** The method of claim 23, wherein said removable substrate material comprises soluble material selected from the group consisting of acid-soluble materials, alkali-soluble materials, organic-solvent-soluble materials, and water-soluble materials.
26. **(Original)** The method of claim 23, wherein said removable substrate material comprises water-soluble polymeric material selected from the group consisting of polyvinyl pyrrolidones (PVP), polyvinyl alcohols (PVA), and polyethylene glycols (PEG).
27. **(Previously presented)** The method of claim 23, wherein said solid core fiber has a cross-sectional outer diameter in a range of from about 10 microns to about 10 millimeters.
28. **(Original)** The method of claim 23, wherein said polymeric membrane-forming material comprises polymeric material selected from the group consisting of polysulfone, polypropylene, polyacrylonitrile, polytetrafluoroethylene, polyethylene, polyvinylidene fluoride, polyamide, polyethyl methacrylate, regenerated cellulose acetate, cellulose triacetate, and mixtures thereof.
29. **(Original)** The method of claim 23, wherein said polymeric membrane-forming material comprises ion-exchange polymeric material selected from the group consisting of perfluorocarbon-sulfonic-acid-based polymers, polysulfone-based polymers, perfluorocarboxylic-acid-based polymers, styrene-vinyl-benzene-sulfonic-acid-based polymers, styrene-butadiene-based polymers, and mixtures thereof.
30. **(Original)** The method of claim 23, wherein said polymeric membrane-forming material comprises perfluorosulfonate ionomer.
31. **(Original)** The method of claim 30, wherein said perfluorosulfonate ionomer is solution extruded over said removable substrate material layer.

4172-120

32. **(Original)** The method of claim 31, wherein the treatment of said perfluorosulfonate ionomer comprises the steps of: (i) drying said perfluorosulfonate ionomer at a first elevated temperature; and (ii) curing said perfluorosulfonate ionomer at a second elevated temperature.
33. **(Original)** The method of claim 32, wherein the first elevated temperature is in a range of from about 25°C to about 100°C.
34. **(Original)** The method of claim 32, wherein the second elevated temperature is in a range of from about 110°C to about 250°C.
35. **(Original)** The method of claim 23, wherein one or more reinforcing fibers are incorporated into said at least one polymeric membrane-forming material layer to form a fiber-reinforced polymeric membrane.
36. **(Original)** The method of claim 35, wherein the solid core fiber has a longitudinal axis, and wherein said reinforcing fibers extend continuously along the longitudinal axis of said solid core fiber.
37. **(Original)** The method of claim 35, wherein said reinforcing fibers comprises fibers selected from the group consisting of fiberglass, carbon fibers, metal fibers, resin fibers, and composite fibers.
38. **(Original)** The method of claim 35, wherein said reinforcing fibers comprises fiberglass yarns.
39. **(Original)** The method of claim 38, wherein said fiberglass yarns are characterized by an average outer diameter in a range of from about 0.1  $\mu\text{m}$  to about 500  $\mu\text{m}$ .
40. **(Original)** The method of claim 35, wherein said reinforcing fibers are co-extruded with said polymeric membrane-forming material layer.
41. **(Original)** The method of claim 35, wherein two layers of polymeric membrane-forming material are coated over said solid core fiber, and wherein said reinforcing fibers are encapsulated between said two polymeric membrane-forming material layers.

4172-120

42. **(Original)** The method of claim 23, further comprising the step of providing a removal interface in contact with at least a portion of said solid core fiber, to facilitate removal thereof.
43. **(Original)** The method of claim 42, wherein said removal interface comprises an open cavity inside the solid core fiber, for passing a removing fluid therethrough to remove the solid core fiber.
44. **(Currently amended)** A method for forming a polymeric hollow fiber, comprising the steps of:
- (a) providing a string or tow of a solid core fiber,
  - (b) passing the string or tow of the solid core fiber through an extrusion die while concurrently extrusion coating at least one ~~substantially circumferentially uniform~~ layer of swellable polymeric membrane-forming material over said solid core fiber,
  - (c) treating said swellable polymeric membrane-forming material layer to form a solidified polymeric membrane;
  - (d) contacting said solidified polymeric membrane with a swelling agent to effectuate expansion and disengagement of such polymeric membrane from the solid core fiber; and
  - (e) removing the solid core fiber from the disengaged solidified polymeric membrane, to form a polymeric hollow fiber comprising a ~~substantially circumferentially uniform~~ tubular membrane wall enclosing an elongated lumen therein.
45. **(Original)** The method of claim 44, wherein said solid core fiber comprises material selected from the group consisting of metals, metal alloys, glass, ceramics, carbons, polymers, and mixtures thereof.
46. **(Previously presented)** The method of claim 44, wherein said solid core fiber has a cross-sectional outer diameter in a range of from about 10 microns to about 10 millimeters.
47. **(Original)** The method of claim 44, wherein said swellable polymeric membrane-forming material comprises ion-exchange polymeric material selected from the group consisting of perfluorocarbon-sulfonic-acid-based polymers, polysulfone-based polymers, perfluorocarboxylic-acid-based polymers, styrene-vinyl-benzene-sulfonic-acid-based polymers, styrene-butadiene-based polymers, and mixtures thereof.

4172-120

48. **(Original)** The method of claim 44, wherein said swelling agent comprises water or an organic solvent.
49. **(Original)** The method of claim 44, wherein polymeric membrane-forming material comprises perfluorosulfonate ionomer, and wherein said swellable agent comprises water.
50. **(Original)** The method of claim 44, wherein one or more reinforcing fibers are incorporated into said at least one swellable polymeric membrane-forming material layer to form a fiber-reinforced polymeric membrane.
51. **(Original)** The method of claim 50, wherein the solid core fiber has a longitudinal axis, and wherein said reinforcing fibers extend continuously along the longitudinal axis of said solid core fiber.
52. **(Original)** The method of claim 50, wherein said reinforcing fibers comprises fibers selected from the group consisting of fiberglass, carbon fibers, metal fibers, resin fibers, and composite fibers.
53. **(Original)** The method of claim 50, wherein said reinforcing fibers comprises fiberglass yarns having an average outer diameter in a range of from about 0.1 $\mu$ m to about 500 $\mu$ m.
54. **(Original)** The method of claim 50, wherein said reinforcing fibers are co-extruded with said swellable polymeric membrane-forming material layer.
55. **(Original)** The method of claim 50, wherein two layers of swellable polymeric membrane-forming material are coated over said solid core fiber, and wherein said reinforcing fibers are encapsulated between said two swellable polymeric membrane-forming material layers.
56. **(Currently amended)** A method for forming an ion-exchange polymeric hollow fiber, comprising the steps of:
- (a) providing a string or tow of a solid core fiber that is subsequently and selectively removable;
  - (b) passing the string or tow of the solid core fiber through an extrusion die while concurrently extrusion coating at least one ~~substantially circumferentially uniform~~ layer of ion-exchange polymeric membrane-forming material over the solid core fiber;

4172-120

- (c) treating such ion-exchange polymeric membrane-forming material layer to form a solidified ion-exchange polymeric membrane; and
- (d) removing the solid core fiber from the solidified ion-exchange polymeric membrane, so as to form an ion-exchange polymeric hollow fiber having a ~~substantially circumferentially uniform~~ tubular membrane wall enclosing an elongated lumen therein.
57. **(Original)** The method of claim 56, wherein said solid core fiber comprises removable substrate material.
58. **(Original)** The method of claim 56, wherein said solid core fiber is coated with removable substrate material.
59. **(Original)** The method of claim 56, wherein the ion-exchange polymeric membrane-forming material comprises material selected from the group consisting of perfluorocarbon-sulfonic-acid-based polymers, polysulfone-based polymers, perfluorocarboxylic-acid-based polymers, styrene-vinyl-benzene-sulfonic-acid-based polymers, styrene-butadiene-based polymers, and mixtures thereof.
60. **(Original)** The method of claim 56, wherein one or more reinforcing fibers are incorporated into said at least one ion-exchange polymeric membrane-forming material layer to form a fiber-reinforced ion-exchange polymeric membrane.
61. **(Original)** The method of claim 60, wherein the solid core fiber has a longitudinal axis, and wherein said reinforcing fibers extend continuously along the longitudinal axis of said solid core fiber.
62. **(Original)** The method of claim 60, wherein said reinforcing fibers comprises fibers selected from the group consisting of fiberglass, carbon fibers, metal fibers, resin fibers, and composite fibers.
63. **(Original)** The method of claim 60, wherein said reinforcing fibers comprises fiberglass yarns having an average outer diameter in a range of from about 0.1 $\mu$ m to about 500 $\mu$ m.
64. **(Original)** The method of claim 60, wherein said reinforcing fibers are co-extruded with said ion-exchange polymeric membrane-forming material layer.



4172-120

65. **(Previously presented)** The method of claim 60, wherein two layers of ion-exchange polymeric membrane-forming material are extrusion coated over said solid core fiber, and wherein said reinforcing fibers are encapsulated between said two ion-exchange polymeric membrane-forming material layers.

66. **(Currently amended)** A method for forming a polymeric hollow fiber, comprising the steps of:

- (a) providing a string or tow of a solid core fiber that is subsequently and selectively removable;
- (b) passing the string or tow of the solid core fiber through an extrusion die while concurrently extrusion coating at least one ~~substantially circumferentially uniform~~ layer of a mixture over the solid core fiber, wherein said mixture comprises polymeric membrane-forming material and removable pore-forming material;
- (c) treating such mixture layer to form a solidified membrane structure; and
- (d) removing the solid core fiber from the solidified membrane structure; and
- (e) removing the pore-forming material from the solidified membrane structure, to form a polymeric hollow fiber having a ~~substantially circumferentially uniform~~ porous tubular membrane wall enclosing an elongated lumen therein,

wherein steps (d) and (e) is carried out either simultaneously, or sequentially in any order.

67. **(Original)** The method of claim 66, wherein said solid core fiber comprises removable substrate material.

68. **(Original)** The method of claim 67, wherein the removable substrate material is essentially the same as the removable pore-forming material, and wherein removal of the solid core fiber is carried out simultaneously with removal of the pore-forming material.

69-70. **(Cancelled).**

71. **(Currently amended)** A method for forming a fiber-reinforced polymeric hollow fibrous membrane, comprising the steps of:

- (a) providing a string or tow of a solid core fiber that is subsequently and selectively removable, wherein said solid core fiber has a longitudinal axis;
- (b) passing the string or tow of the solid core fiber through an extrusion die while concurrently forming one or more ~~substantially circumferentially uniform~~ layers of polymeric

4172-120

membrane-forming material over the solid core fiber by extrusion of said one or more layers, wherein said polymeric membrane-forming material layers contain one or more reinforcing fibers extending continuously along the longitudinal axis of the solid core fiber;

(c) treating said one or more polymeric membrane-forming material layers to form a solidified fiber-reinforced polymeric membrane; and

(d) removing the solid core fiber from said polymeric membrane, so as to form a fiber-reinforced polymeric hollow fiber having a ~~substantially circumferentially uniform~~ tubular membrane wall enclosing an elongated lumen therein.

72-75. (Cancelled).

76. (Currently amended) A method for forming a polymeric hollow fiber, comprising the steps of:

(a) forming a fibrous precursor structure comprising a string or tow of a fibrous solid core extrusion coated by ~~a substantially circumferentially uniform~~ with a layer of polymeric membrane; and

(b) removing the fibrous solid core from the polymeric membrane, to form a polymeric hollow fiber comprising a ~~substantially circumferentially uniform~~ tubular membrane wall enclosing an elongated lumen therein.

77. (Currently amended) The method of claim 76, wherein said fibrous solid core further comprises ~~a substantially circumferentially uniform~~ an extrusion coating of a removable substrate material layer that can be removed from the polymeric membrane to form said polymeric hollow fiber.

78. (Currently amended) The method of claim 76, wherein said fibrous solid core comprises a removable substrate material that can be removed from the polymeric membrane to form said polymeric hollow fiber.

79. (Previously presented) The method of claim 76, wherein said polymeric membrane comprises a swellable polymeric membrane material that expands and disengages said polymeric membrane from the fibrous solid core upon contact with a swelling agent, so that the fibrous solid core can be removed from the disengaged polymeric membrane to form said polymeric hollow fiber.

4172-120

80. (Currently amended) The method of claim ~~[[76]]~~ 77, wherein said fibrous solid core further comprising said ~~comprises a removable substrate material that can be removed from the polymeric membrane to form the polymeric hollow fiber, and wherein said fibrous core and said polymeric membrane are formed by a co-extrusion process.~~

81. (New) The method of claim 1 wherein the at least one layer of removable substrate material or the at least one layer of a polymeric membrane-forming material or both are substantially circumferentially uniform.

82. (New) The method of claim 23 wherein the at least one layer of polymeric membrane-forming material is substantially circumferentially uniform.

83. (New) The method of claim 44 wherein the at least one layer of swellable polymeric membrane-forming material is substantially circumferentially uniform.

84. (New) The method of claim 56 wherein the at least one layer of ion-exchange polymeric membrane-forming material is substantially circumferentially uniform.

85. (New) The method of claim 66 wherein the at least one layer of the mixture is substantially circumferentially uniform.

86. (New) The method of claim 71 wherein the one or more layers of polymeric membrane-forming material is substantially circumferentially uniform.

87 (New) The method of claim 76 wherein the polymeric membrane is substantially circumferentially uniform.